



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4406-1
Job Sheet 171178



17

Part No: D4406-1

Job Qty: 6 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 2/6/18

Type: SOLD

Description:

Note: DWG REV D IPP REV:A 14.04.09 DWG REV:C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/5/18	0.00	0.00	Start Up Waterjet		SC 18/01/31
100	Waterjet	6 pcs		2/5/18	0.00	1.20	Waterjet1		SC 18/01/31
110	QC	6 pcs		2/5/18	0.00	0.00	QC2 Waterjet-3		SC 18/01/31
120	QC	6 pcs		2/5/18	0.00	0.00	QC8-4		EB
130	Small Fab	6 pcs		2/6/18	0.11	0.40	Small Fab-6		EB JB
140	QC	6 pcs		2/6/18	0.00	0.00	QC5		EB
150	Packaging	6 pcs		2/6/18	0.00	0.00	Packaging3		Q
160	QC21-SA	6 Ea		2/6/18	0.00	0.00	QC21		

DAG
21
9-20

FEB 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	21 sf (3.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	21 17.45	97	0

SO 92213

Part Specifications

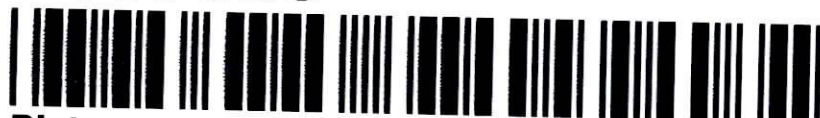
Specifications could not be found.

Plex 1/30/18 8:03 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S037686

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Plate

PART NO: D4406-1

Original Serial #: S037686

Revision:

Operation:

Change No:

Start up Operation

01/31/18

Job No: 171178

DART AEROSPACE LTD		Work Order:	171178
Description: Plate		Part Number:	D4406-1
Inspection Dwg: D4406	Rev: C	Page 1 of 1	

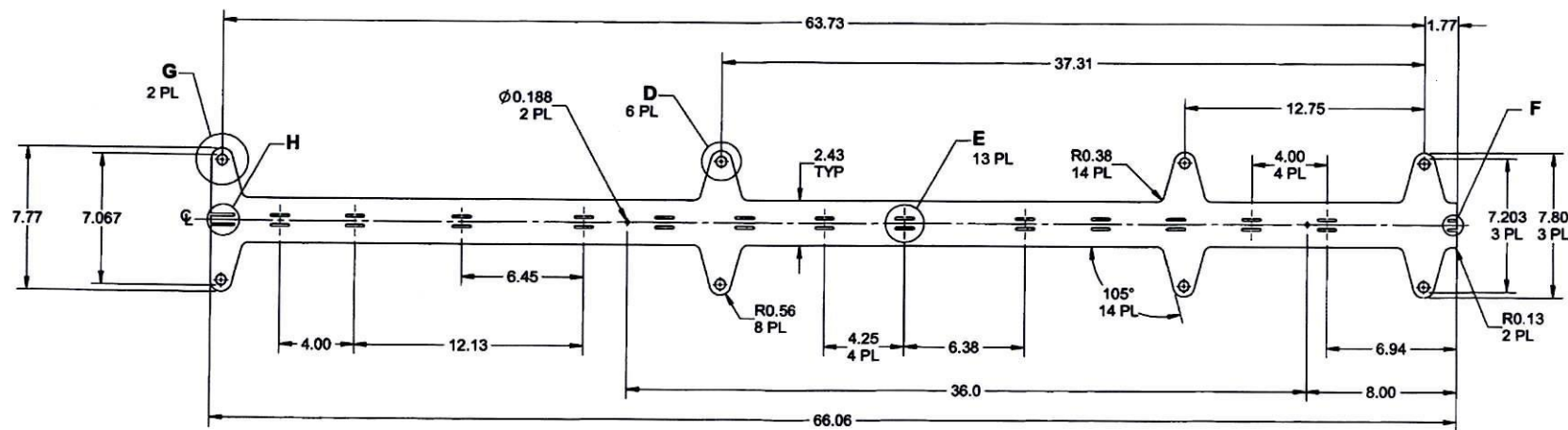
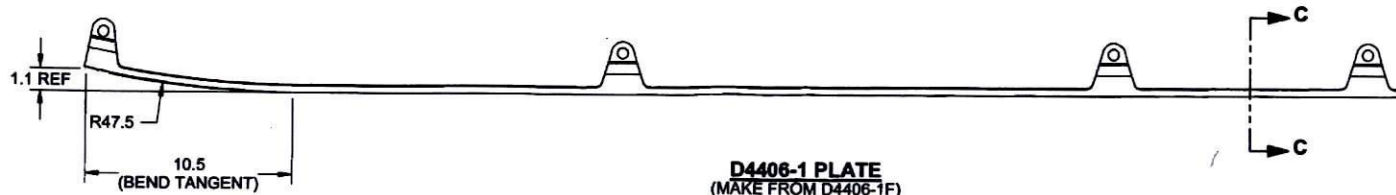
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.561	+/-0.010	0.567			UDC-2	
0.30	+/-0.030	0.308			Tape	
1.00	+/-0.030	1.005				
0.13	+/-0.030	0.131				
1.77	+/-0.030	1.776				
7.203	+/-0.010	7.205				
7.80	+/-0.030	7.794				
8.00	+/-0.030	8.005				
6.94	+/-0.030	6.946				
4.00	+/-0.030	4.01				
36.00	+/-0.030	36.00				
66.06	+/-0.030	66.06				
2.43	+/-0.030	2.435				
7.067	+/-0.010	7.068				
7.77	+/-0.030	7.76				
12.745	+/-0.010	12.754				
37.31	+/-0.010	37.315				
63.735	+/-0.010	63.73				
0.050	+/-0.010	0.058				
0.188	+0.005/-0.001	0.198				
6.38	+/-0.030	6.387				
4.25	+/-0.030	4.256				
6.45	+/-0.030	6.455				
12.13	+/-0.030	12.139				
4.00	+/-0.030	4.005				

Measured by: SC	Audited by: EP	Preliminary Approval:
Date: 18/01/31	Date: FEB 01 2018	Date:

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-041	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	
C	13.05.27	Dimensions revised per Dwg Rev C	KJ	MA

8 7 6 5 4 3 2 1



D4406-1F
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBMIT TO MANUFACTURING
WORK ORDER
NO. 171178
18/01/30

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.10.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1